



Dart Hawkesbury  
1270 Aberdeen St  
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Canada

Tel (613) 632-5200

**D2939-1RLC**  
**Job Sheet 167733**



Part No: D2939-1RLC

Job Qty: 2 ea

Part Name: Saddle LH In, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/6/17

Job Tracking No:

Due Date: 12/8/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Ship Via:

Rev C.

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off      |
|-------|------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|---------------|
|       |                        |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |               |
| 90    | Start up Operation     | 2 Ea  |            | 12/7/17  | 0.00      | 0.00    | Start Up Machining    |           | FK 17-12-2    |
| 100   | CNC Vertical Machining | 2 pcs |            | 12/7/17  | 0.00      | 2.38    | HAAS 1                |           | FK 17-12-4    |
| 110   | Mill Conv              | 2 pcs |            | 12/7/17  | 0.00      | 0.00    | Mill Conv 1           |           | FK 17-12-4    |
| 120   | QC                     | 2 pcs |            | 12/7/17  | 0.00      | 0.00    | QC1                   |           | FK 17-12-4    |
| 130   | QC                     | 2 pcs |            | 12/7/17  | 0.00      | 0.00    | QC8                   |           | FK 17-12-04   |
| 140   | HandFinish             | 2 pcs |            | 12/7/17  | 0.00      | 0.14    | HandFinish1           |           | 2017-12-12-28 |
| 150   | SprayPaint             | 2 pcs |            | 12/8/17  | 0.00      | 0.21    | Spray Paint           |           | 11 JAN 10 21  |
| 160   | QC                     | 2 pcs |            | 12/8/17  | 0.00      | 0.00    | QC14                  |           | AT 18-09-10   |
| 170   | Packaging              | 2 pcs |            | 12/8/17  | 0.00      | 0.00    | Packaging3            | 57405     |               |
| 180   | QC21-SA                | 2 Ea  |            | 12/8/17  | 0.00      | 0.00    | QC21                  |           |               |

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

150 - (Boeing primer and same paint as float skidtubes).

Prime 138108  
Paint 138669

### Job Allocations

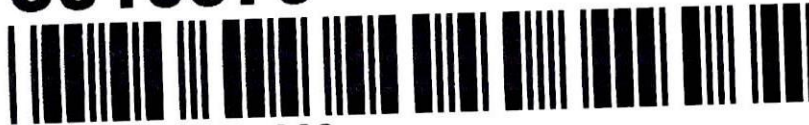
| Operation             | Component Part    | Required | Inventory | Allocated | Std Qty |
|-----------------------|-------------------|----------|-----------|-----------|---------|
| 90-Start up Operation | D6101-001         | 2        | 29        | 0         | 0       |
|                       | F164403 (5016574) |          |           |           |         |

### Part Specifications

Specifications could not be found.

Plex 11/6/17 10:41 AM dart.Michaud-Febrille.Victoria

**DART**  
AEROSPACE  
**S016575**



Saddle LH In, 206

**Dart Aerospace Ltd.**

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**PART NO:**

**D2939 – 1RLC**

**Revision:**

**Operation:**

**Change No:**

**Start up Operation**

**Mfg Date: 12/02/17**

**Job No: 167733**



|                                                    |                     |                    |
|----------------------------------------------------|---------------------|--------------------|
| <b>DART AEROSPACE LTD</b>                          | <b>Work Order:</b>  |                    |
| <b>Description:</b> 206 Saddle, Inboard, Left side | <b>Part Number:</b> | <b>D2939-1</b>     |
| <b>Inspection Dwg:</b> D2939 Rev. C                |                     | <b>Page 1 of 1</b> |

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

|               |       |       |                | Recorded Actual Dimensions |       |   |   | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|---|---|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                          | 2     | 3 | 4 |    |      |
| A             | 0.100 | 0.140 |                | .115                       | .116  |   |   |    |      |
| B             | 0.100 | 0.140 |                | .116                       | .113  |   |   |    |      |
| C             | 0.100 | 0.140 |                | .117                       | .118  |   |   |    |      |
| D             | 0.210 | 0.230 |                | .224                       | .225  |   |   |    |      |
| E             | 1.245 | 1.255 |                | 1.250                      | 1.250 |   |   |    |      |
| F             | 1.245 | 1.255 |                | 1.250                      | 1.250 |   |   |    |      |
| G             | 2.495 | 2.505 |                | 2.500                      | 2.500 |   |   |    |      |
| H             | 0.510 | 0.515 |                | .511                       | .511  |   |   |    |      |
| I             | 1.572 | 1.582 |                | 1.577                      | 1.577 |   |   |    |      |
| J             | 2.495 | 2.505 |                | 2.500                      | 2.500 |   |   |    |      |
| K             | 0.257 | 0.262 |                | .258                       | .258  |   |   |    |      |
| L             | 0.312 | 0.317 |                | .313                       | .313  |   |   |    |      |
| M             | 0.235 | 0.240 |                | .237                       | .238  |   |   |    |      |
| N             | 0.100 | 0.140 |                | .120                       | .121  |   |   |    |      |
| O             | 0.540 | 0.560 |                | .549                       | .550  |   |   |    |      |
| P             | 0.490 | 0.510 |                | .500                       | .500  |   |   |    |      |
| Q             | 3.715 | 3.725 |                | 3.720                      | 3.720 |   |   |    |      |
| R             | 2.720 | 2.760 |                | 2.743                      | 2.744 |   |   |    |      |
| S             | 0.240 | 0.270 |                | .234                       | .255  |   |   |    |      |
| T             | 0.100 | 0.180 |                | .135                       | .135  |   |   |    |      |
| U             | 1.625 | 1.635 |                | 1.630                      | 1.630 |   |   |    |      |
| V             | 1.362 | 1.372 |                | 1.367                      | 1.367 |   |   |    |      |
| W             | 0.316 | 0.321 |                | .316                       | .316  |   |   |    |      |
| X             | 1.250 | 1.270 |                | 1.260                      | 1.260 |   |   |    |      |
| Y             | 1.565 | 1.585 | DT8695 A/B     | 1.575                      | 1.575 |   |   |    |      |
| Z             | 0.178 | 0.198 |                | .188                       | .188  |   |   |    |      |
| AA            |       |       |                |                            |       |   |   |    |      |
| AB            |       |       |                |                            |       |   |   |    |      |
| AC            |       |       |                |                            |       |   |   |    |      |
| AD            |       |       |                |                            |       |   |   |    |      |
| AE            |       |       |                |                            |       |   |   |    |      |
| AF            |       |       |                |                            |       |   |   |    |      |
| AG            |       |       |                |                            |       |   |   |    |      |
| AH            |       |       |                |                            |       |   |   |    |      |
| Accept/Reject |       |       |                | ✓                          | ✓     |   |   |    |      |

|              |         |
|--------------|---------|
| Measured by: | FK      |
| Date:        | 17-12-3 |

|             |          |
|-------------|----------|
| Audited by: | h.p      |
| Date:       | 17-12-04 |

| Rev | Date     | Change                                                        | Revised by | Approved |
|-----|----------|---------------------------------------------------------------|------------|----------|
| A   |          | New Issue                                                     | RF         |          |
| B   | 02.12.12 | Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B | KJ/RF      |          |
| C   | 07.03.21 | Revised per drawing revision C                                | KJ/JLM     |          |